

Work Order ID 60374

Page 1

July 6, 2010 2:58:07 PM

Item ID: D3774-3

Accept



Setup Start

**Revision ID:****Item Name:** Seat Back, LH/RH

Stop

**Start Date:** 7/06/10 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 7/20/10 **Req'd Qty:** 2.00**Customer:****Reference:****Approvals:****Process Plan:** *CZ***Date:** *10/17/10***Tooling:****Date:**

Run Start

**QC:****Date:****SPC (Y/N):****Date:**

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr
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D3774	Rev B
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100 *10/07/10*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine *10/07/10*

Set up machine program D3774-3 Set up clamping frame as per folio

110 *10/07/10*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine *10/07/10*

Cut Blanks

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3774-3

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Setup Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 7/06/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



Dry Material

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240FTime IN: 4:30 PM 10/07/18 BBTime OUT: 7:00 AM 10/07/19 BB

BB
10/07/19

120



THERMOFORMING MACHINE

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D32811 and Folio FTA 011 Dwg. Rev.

B Folio Rev. C

X2 BB
10/07/19

130



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

X2 BB
10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60374

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Item ID: D3774-3

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Setup Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 7/06/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

140

**Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

150



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

1) Check dimensions to ensure conformity to drawing tolerances.

160



Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Eulon/21

X2
BB

10/07/20

X2
BL

10/07/20

X2

M 10-124

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 60374

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Item ID: D3774-3

Accept



Setup

Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 7/06/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**

170



Packaging

Packaging

**Set Up/
Run Hours**

Tool ID

Tool #

Plan

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Identify as per dwg & Stock Location *257*

0.00

Memo

180



QC

Quality Control

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

*10-7-20 22 2011**10/07/2011**mf**10-7-20*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60374



Parent Item: D3774-3



Parent Item Name: Seat Back, LH/RH

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL
Add Step 115 Dry Material 10/04/21 DL

Ipp Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	687.7068	10.667	21.334			

GE PLASTICS LEXAN SHEET



Location	Loc Qty	Loc Code
MAT	687.7068	
111710	64	
112585	155.783	
114032	467.9238	

12/03 10/07/19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60374
Description: Seat Back	Part Number:	D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 10/07/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.348	✓			
33.9	+/-0.100	33.9	✓			
0.085	Min	.093	✓			
0.100	Min	103	✓			
0.100	Min	118	✓			
0.100	Min	120	✓			
0.100	Min	119	✓			
0.100	Min	119	✓			
0.100	Min	115	✓			
0.100	Min	105	✓			
0.100	Min	N/A	N/A			

Measured by: BB

Date: 10/07/20

Audited by: W

Date: 10/07/20

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	<u>MM</u>

8 7 6 5 4 3 2 1

D

D

C

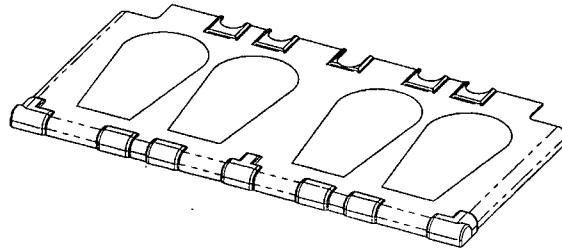
C

B

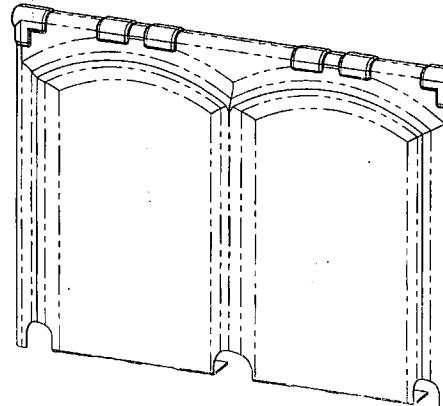
B

A

A



D3774-1 SEAT BOTTOM

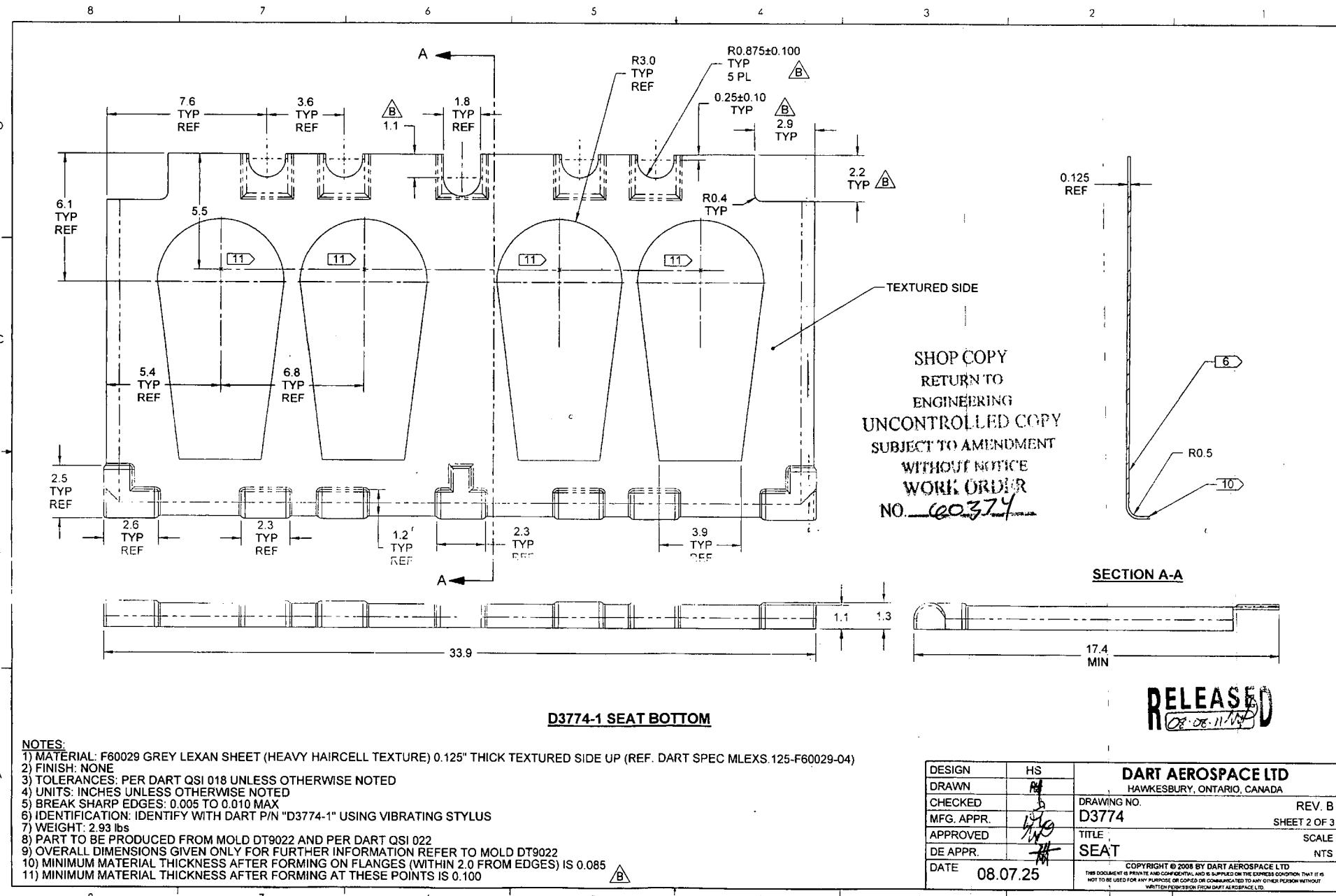


D3774-3 SEAT BACK

RELEASED
06-08-11-11

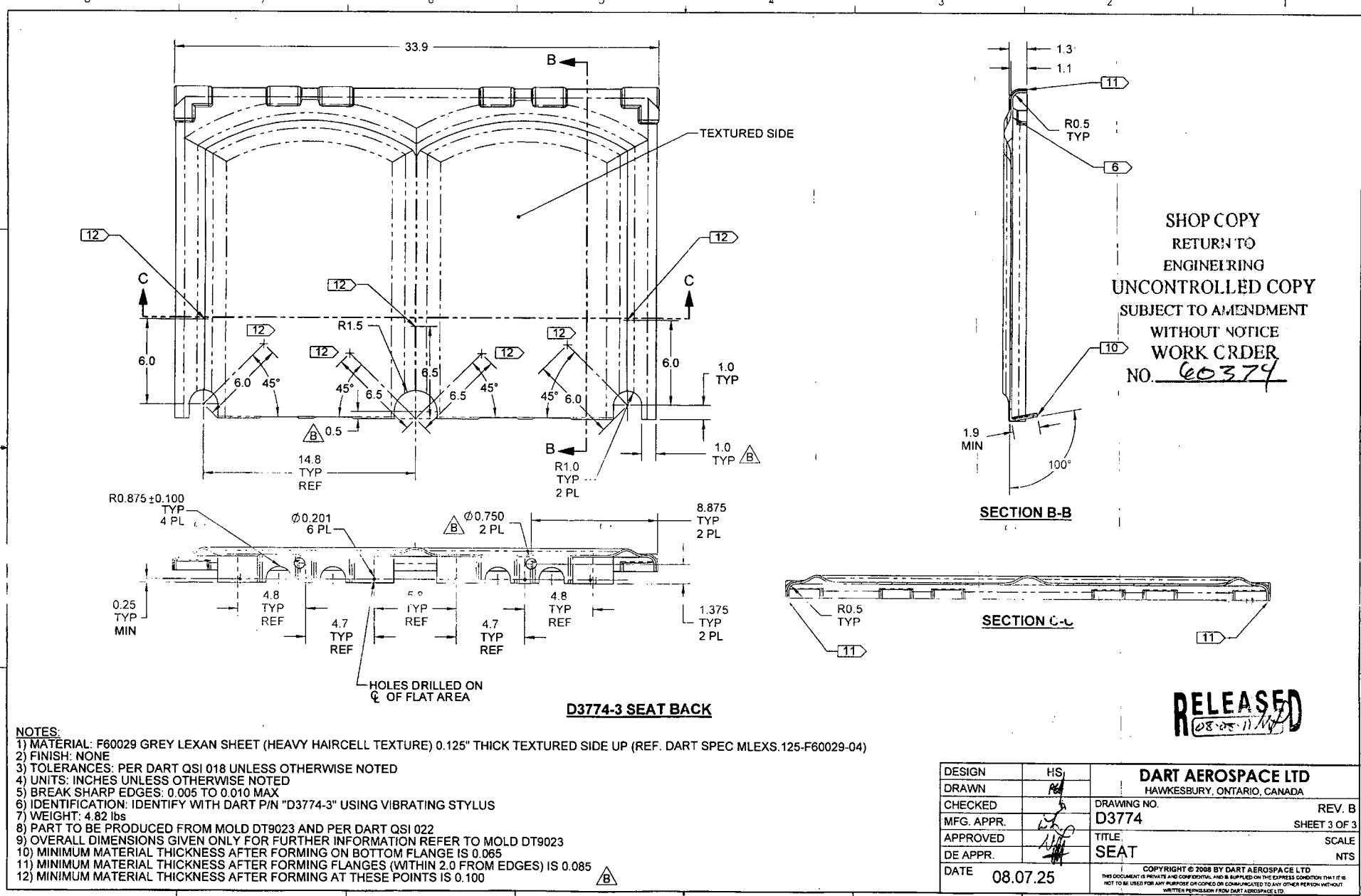
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO - *60374*
CL101714

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES			PH	08.07.25
A	NEW ISSUE			HS	08.06.23
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	<i>PH</i>	DRAWING NO.		REV. B	
CHECKED	<i>PH</i>	D3774		SHEET 1 OF 3	
MFG. APPR.	<i>PH</i>	TITLE		SCALE	
APPROVED	<i>PH</i>	SEAT		NTS	
DE APPR.	<i>PH</i>				
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MFG. APPR.	✓	REV. B	SHEET 2 OF 3
APPROVED	✓	TITLE: SEAT	SCALE NTS
DE APPR.	✓	DATE 08.07.25	

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CHECKED	RE	DRAWING NO. D3774
MFG. APPR.	RE	REV. B
APPROVED	RE	SHEET 3 OF 3
DE APPR.	RE	TITLE: SEAT
DATE 08.07.25	RE	NTS

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